

26

Date: Friday, 5/25/2007 12:51:25 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212/205 HIGH AFT X-TUBE ASSEMBLY
Job Number	: 32681		
Estimate Number	: 10257		
P.O. Number	: N/A	Part Number	: D212664201
This Issue	: 5/25/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D212-664-241 REV C
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32680	Drawing Revision	: C
		Material	: N/A
		Due Date	: 6/30/2007
Written By	: <u>HA 07.05.28</u>	Qty:	1 Um: Each
Checked & Approved By	: <u>HA 07.05.28</u>		
Comment	Est Rev:E 04.02.16 Reformat K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM Est Rev:G 07-04-30 As per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



KS 07.06.05 (1)

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG003

5 added of

2.0	D6006129	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
-----	-------------	-------------	-------

1	D6006-129	Crosstube	25666
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Check OD = 3.250"; ID = 2.220"

36 07.07.09 (1)

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

36 07.07.09

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

36 07.07.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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5.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241. *BC 07-07-09*

6.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

SB/07/07/10

7.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 07-07-10

8.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

ml 07/07/12

9.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

Jh 7-7-12

10.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Sn 07/07/12

11.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

Jh 7-7-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 32681

Part Number: D212664201

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

12.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

EL 07/07/25 (D)

13.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

EL 7-8-21

14.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

Jul 09-11 (D)

15.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

EL/SR
7-9-26

JD 7-9-27

16.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

JD 7-9-27

17.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EL 07/09/26

18.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

checked holes
EL 07/09/26

19.0	OUTSIDE SERV.10	OUTSIDE SERVICES -LG
------	-----------------	----------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 4701

LPI as per ASTM 1417 Level 2

CO 07/09/27 (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 32681

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

Attach copy of NDT results to work order

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

5/25/27

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

5/25/27 (20)

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

7 ml 07 09 29

(1)

23.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

21 07 08 03

24.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1

Support

32780

ml 07 09 30

25.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0242 sf(s)/Unit Total : 0.0242 sf(s)

Rubber Cushion (per sq ft)

.63" x 5.300

Batch:

33834

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 32681

Part Number: D212664201

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

26.0	MS2192028	Clamp(per MIL-DTL-8783C)
------	-----------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

104423

ml 07 09 30

27.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
------	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Install supports with magnobond as per QSI 015. Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: m104723

Expiry Date: 04/2008

Time: 1:30pm

ml 07 09 30

2-Install clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb:

28.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

6/27/06/03

29.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0	D34281	Placard
------	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B26249

CE

31.0	AN640A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104374

CE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/10/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 32681

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100743

W

33.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M104745

W

34.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M104021

W 7/10/03 (1)

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

W 7/10/04

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

W 7/10/07 (1)

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

W 7/10/07 (1)

Job Completion



W 7/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32681
Description: Crosstube Assembly (205/212 High Alt)		Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: <i>PC</i> <i>07.05.20</i>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

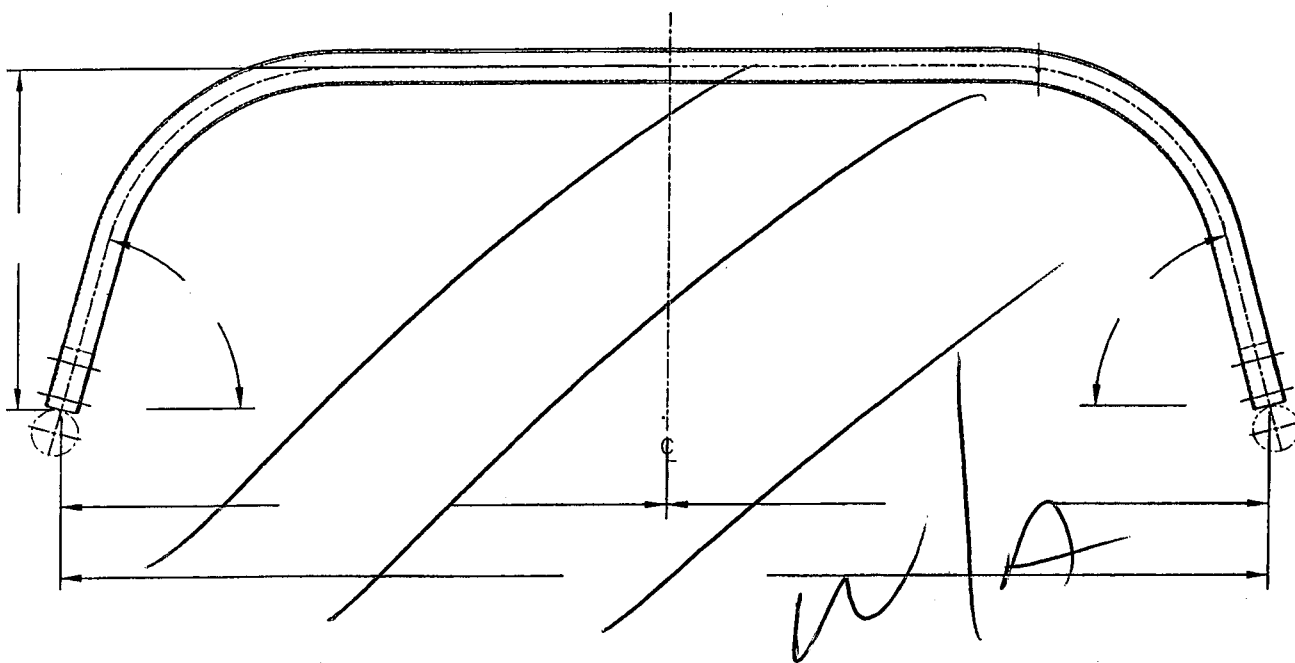
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	<i>200</i>	✓		
	R0.063	+/-0.010	<i>0.063</i>	✓		
	2.990	+0.005/-0.000	<i>2.995</i>	✓		
	5.237	+/-0.030	<i>5.237</i>	✓		
	2.600	+0.005/-0.000	<i>2.605</i>	✓		
	2.686	+0.005/-0.000	<i>2.691</i>	✓		
	2.770	+0.005/-0.000	<i>2.775</i>	✓		
	2.854	+0.005/-0.000	<i>2.859</i>	✓		
	2.938	+0.005/-0.000	<i>2.943</i>	✓		
	3.021	+0.005/-0.000	<i>3.026</i>	✓		
	3.133	+0.005/-0.000	<i>3.138</i>	✓		
	3.179	+0.005/-0.000	<i>3.184</i>	✓		
SIDE B	0.200	+/-0.010	<i>0.200</i>	✓		
	R0.063	+/-0.010	<i>0.063</i>	✓		
	2.990	+0.005/-0.000	<i>2.991</i>	✓		
	5.237	+/-0.030	<i>5.236</i>	✓		
	2.600	+0.005/-0.000	<i>2.600</i>	✓		
	2.686	+0.005/-0.000	<i>2.686</i>	✓		
	2.770	+0.005/-0.000	<i>2.772</i>	✓		
	2.854	+0.005/-0.000	<i>2.855</i>	✓		
	2.938	+0.005/-0.000	<i>2.934</i>	✓		
	3.021	+0.005/-0.000	<i>3.022</i>	✓		
	3.133	+0.005/-0.000	<i>3.136</i>	✓		
	3.179	+0.005/-0.000	<i>3.182</i>	✓		
	124.36	+/-0.020	<i>124.36</i>	✓		

Measured by: <i>PC</i>	Audited by: <i>SA</i>	Prototype Approval:	N/A
Date: <i>07/07/10</i>	Date: <i>07.07.10</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	<i>SA</i>
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	<i>SA</i>

DART AEROSPACE LTD		Work Order:	32681
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241	Rev: <i>EC</i> <i>07-02-08</i>	Page 1 of 1	

Required Dimension	Min	Max
Height	24.24	24.36
1/2 Span	53.66	53.78
Angle	49	52
Total Span	107.32	107.56



Comments
<i>EC 07/02/08</i>

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D212-664-241	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

RELEASED
07.04.24
PER E.C.N. 2259

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP (OR MS21920-30)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT

NOTE: MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.

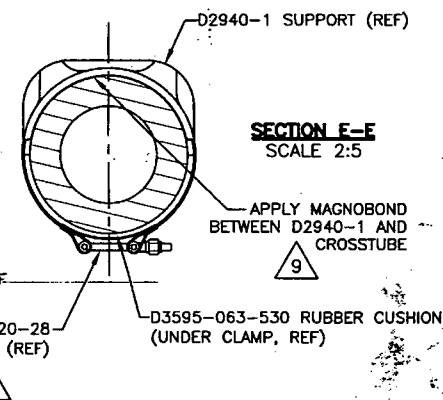
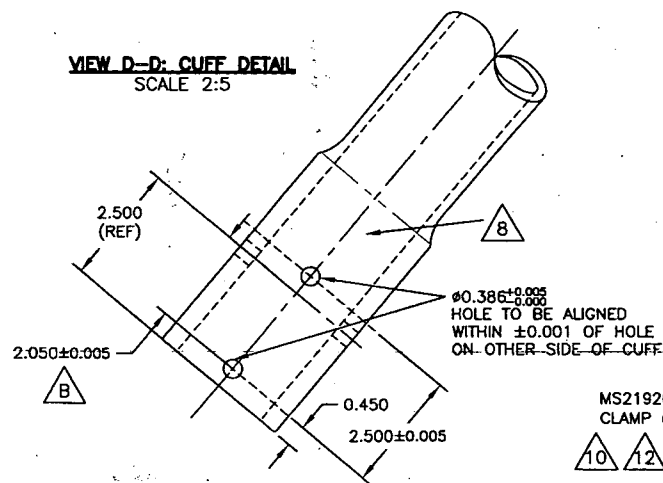
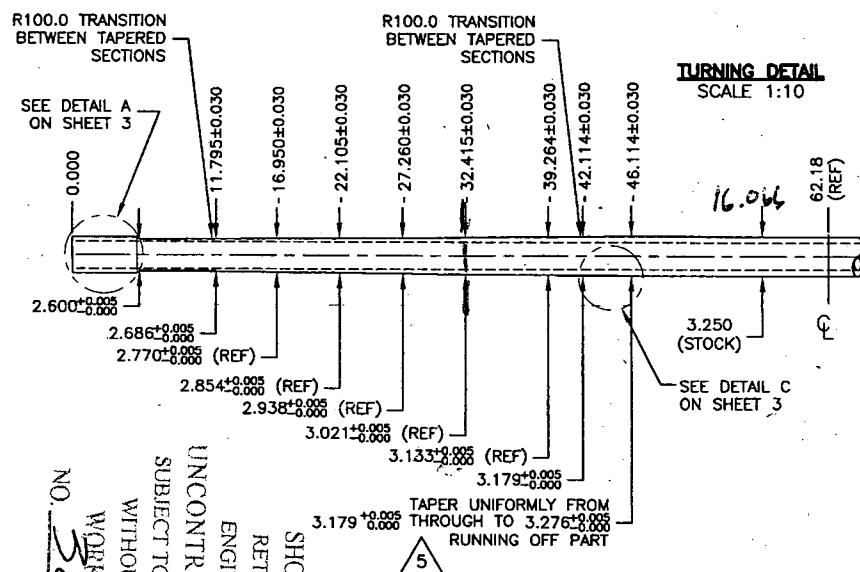
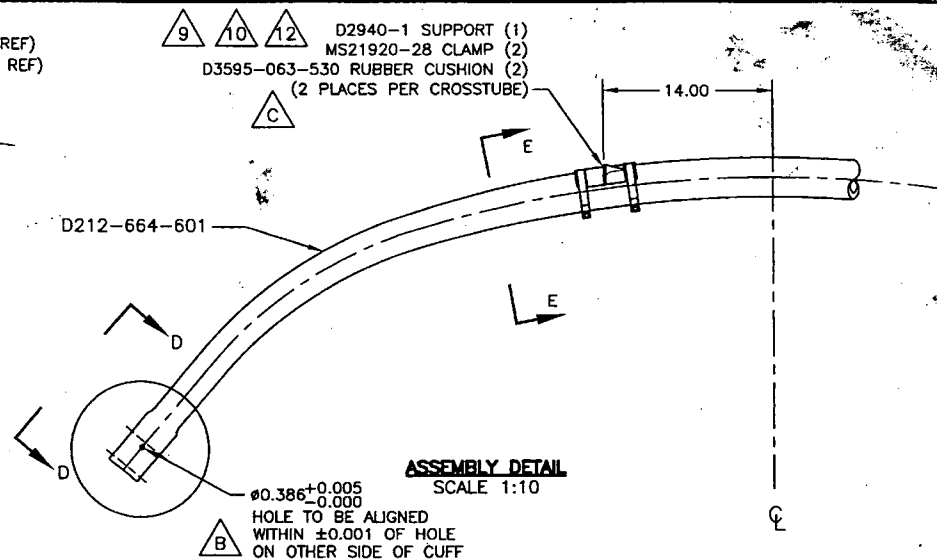
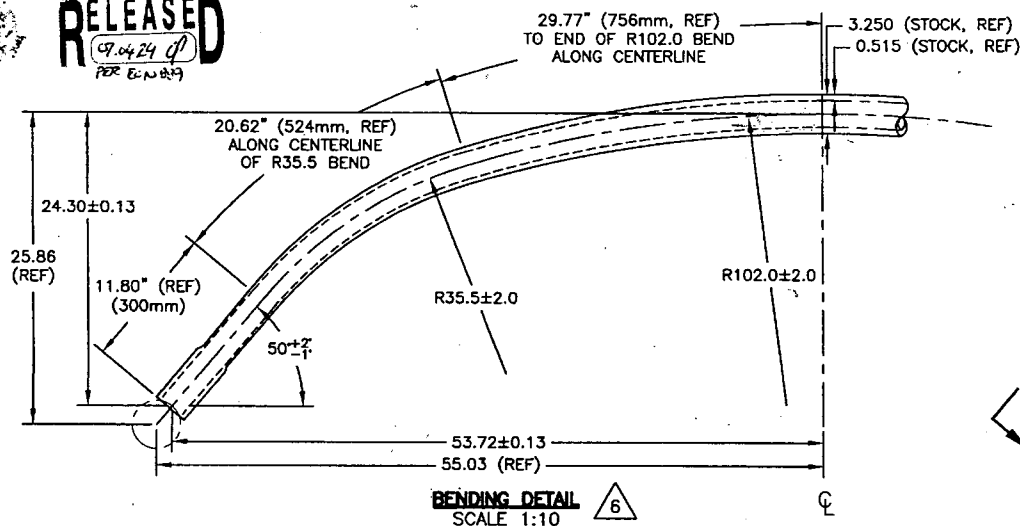
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *32681*

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RELEASED
9.04.24
PER E.N. 24



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DESIGN PH

DRAWN BY PH

CHECKED J

APPROVED A

DATE 07.03.08

DART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

DRAWING NO. D212-664-241

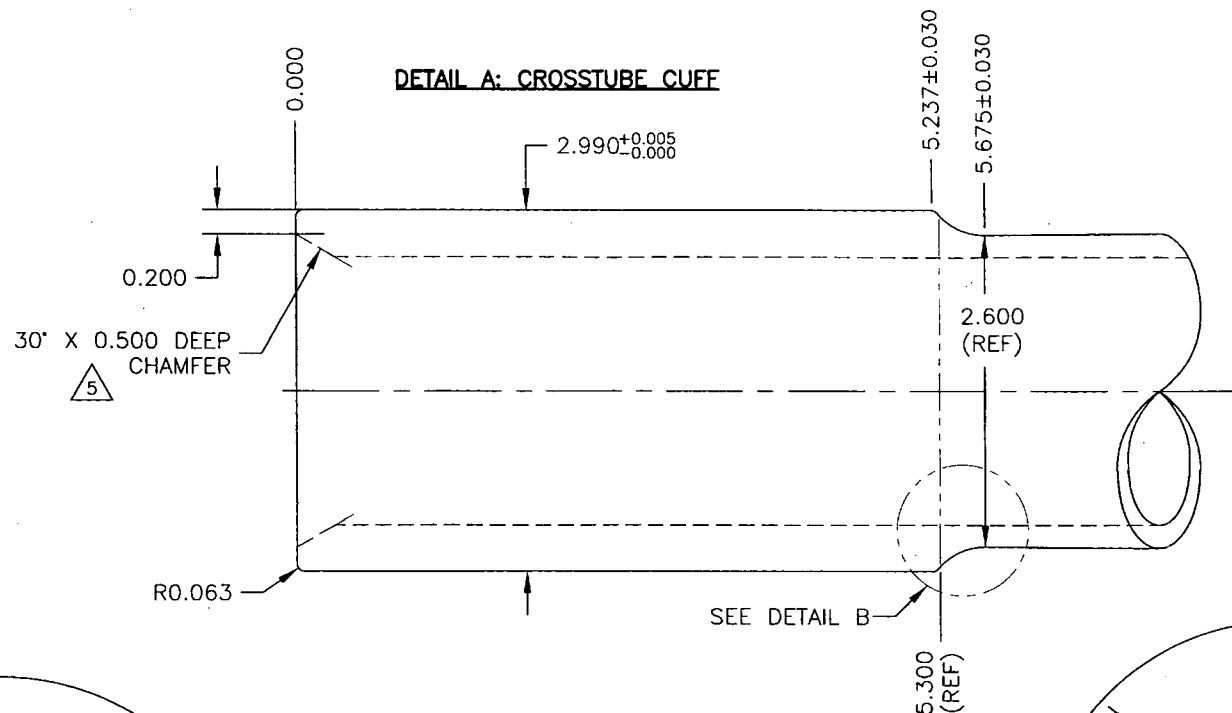
REV. C
SHEET 2 OF 3

TITLE CROSSTUBE ASS'Y (205/212 HI AFT) SCALE 1:10

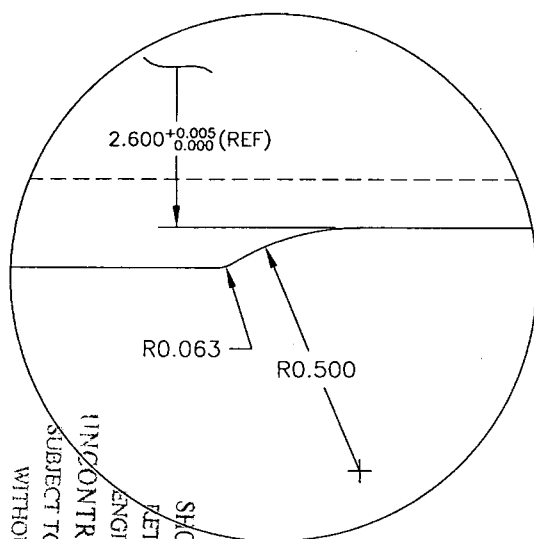
WORK ORDER NO. 32681
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

RELEASED
 070424 P
 PER ECN 889

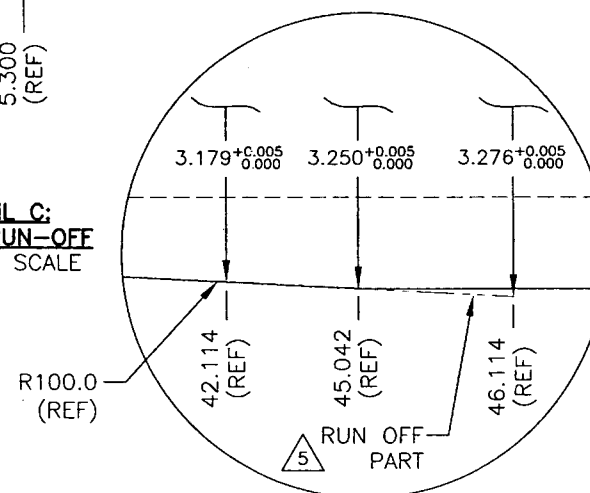
DETAIL A: CROSSTUBE CUFF



**DETAIL B: CUFF
 TRANSITION
 SCALE 4:1**



**DETAIL C:
 TAPER RUN-OFF
 NOT TO SCALE**



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 DART AEROSPACE LTD.

DESIGN

DRAWN BY

DART

DART AEROSPACE LTD.
 WATKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.
 D212-664-241

REV. C
 SHEET 3 OF 3

DATE

TITLE

SCALE

07.03.08

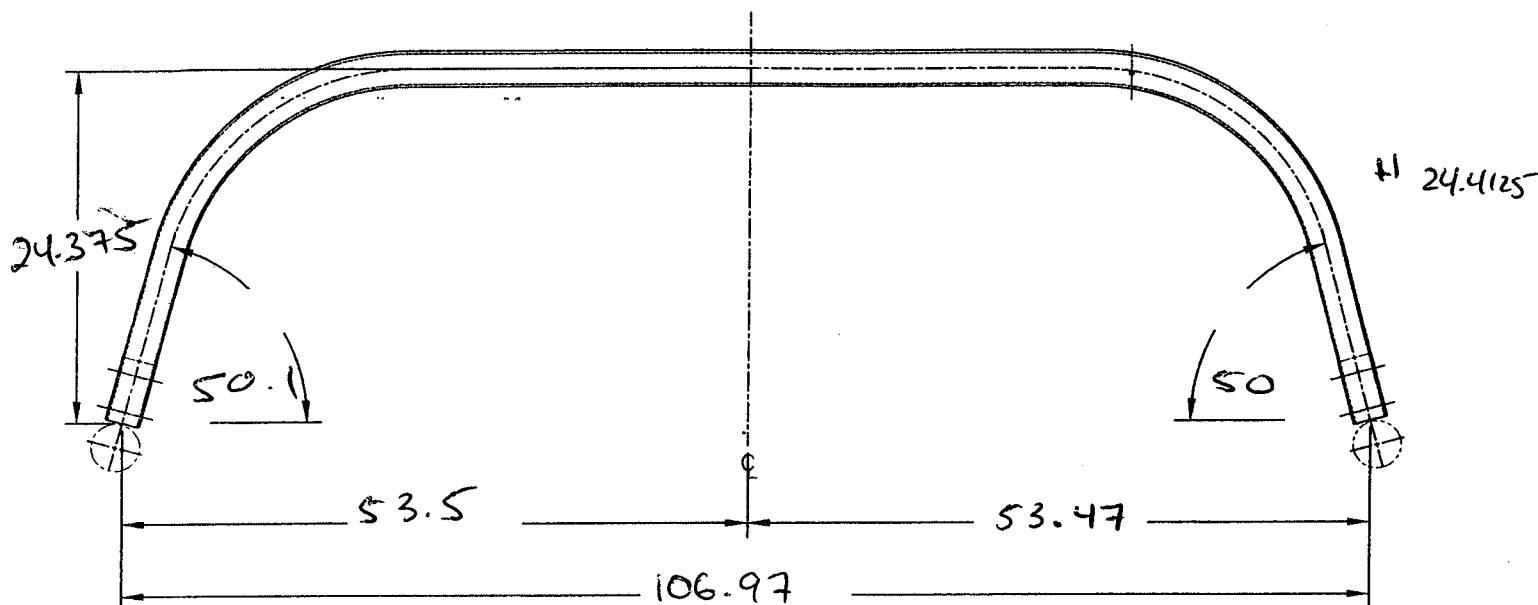
CROSSTUBE ASS'Y (205/212 HI AFT)

1:1

NO. 32681
 WORK ORDER
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 UNCONTROLLED COPY
 RETURN TO
 ENGINEERING
 SHOP COPY

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
height is slightly un-even. acceptable: within tolerance. Dim 3 Tube is in on spans, but is acceptable per Q51042.

QC15 Inspection	<i>[Signature]</i> Q51042
Date	0709-11

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	<i>[Signature]</i>



LIQUID PENETRANT TEST REPORT

P - 1178 1

CLIENT	DART AEROSPACE	DATE	SEP 27 2007	PAGE	1	OF	2
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 07 1178	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST	PO/NO.					
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY				
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
PROJECT	206L AFT X TUBES, 212/205 HIGH AFT X TUBE						
ITEM(S) EXAMINED	JOB #S 31038, 32142, 34043, 34051, 34482, 32681.						

JOB DESCRIPTION	PROCEDURE NO. LT-0002	REV./DATE	TECHNIQUE NO. LT-TECH2	REV./DATE
PART NO. D206667203/D212664201	MATERIAL	7075 ALODINED ALUM.	THICKNESS	
SCOPE	WET FLOURESCENT LIQUID PENETRANT-INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE			

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/CM ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL SEP 18 07	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input checked="" type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL SURFACE ON:
206L AFT X TUBES JOB#S 31038, 32142,
34043, 34051, 34482.
212 HIGH AFT X TUBE JOB# 32681.

RESULTS: NO INDICATION OF DEFECTS.
ITEMS ACCEPTABLE TO STANDARD.

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE		SIGNATURE	DTR # E 13167
TECHNICIAN (SIGNATURE):			REPORT REVIEWED BY:
NAME (PRINT):	JASON HEWETT		NAME INITIALS
	1 ST TECHNICIAN	2 ND TECHNICIAN	
CGSB LEVEL	2	SNT LEVEL	
CGSB REG. NO	6156	CGSB REG. NO	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

Date: Thursday, 10/01/2008 9:07:57 AM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D212-664
Job Number : 36700	
Estimate Number : 10804	
P.O. Number :	Part Number : Z_CUSTOM
This Issue : 10/01/2008 S.O. No. :	Drawing Number : ECN 1103
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LANDING GEAR	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 17/01/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STK:

(12) -4 D212-664-101
-4 D212-664-201

✓ D412-664-203

35872-35871-35539
35929-35928-35870-35873-35927-35541-
32681-32684-32680-34886-32151
35720-35056-35106

ADD NEW PAPERWORK TO KITS IN STK

FAA STC: SR01298NY, PER ECN 1103

RETURN TO STOCK

17x 2/1/11 SGP

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11 08-06-11